

# Work Order ID 123580

August-13-14 7:59:24 AM

Page 1

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Start Qty: 10.00

Required Date: 8/13/14

Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: 14-08-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

Document Control

0.00

\*100\*

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CH0001

110

\*110\*

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush

DAS  
38  
9-89

14-8-12

10. 9 DMC 14.08.25

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**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

[illegible]

# Work Order ID 123580

\*123580\*

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August-13-14 7:59:24 AM

Item ID: D350-591-311 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14 Start Qty: 10.00 \*10\*

Required Date: 8/13/14 Req'd Qty: 10.00 \*10\*

Reference: Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							DAS 9 9-89
*150*									
QC	Memo	0.00							
Quality Control									
180	Large Fab	0.00							
*180*									
Large Fab	Memo	0.00							
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod B128956								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

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Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 8/13/14

Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 8/13/14

Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

**\*190\***

QC

Memo

0.00

Quality Control

10 SEP 10 2014

DAS  
24  
9-89

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

10 SEP 10 2014

DAS  
24  
9-89

210

Chemical Conversion Coat per QSI005 4.1

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

10 11-9-10

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Item ID: D350-591-311 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step™ LH  
 Start Date: 8/13/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 8/13/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 <b>*220*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 128459</i>  Memo START TIME: <i>3:20</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>3:50</i>	0.00  0.00				<i>10 of 14-9-11</i>			DAS 34 9-89
230 <b>*230*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch _____  Memo	0.00  0.00				<i>x 10 LTI of 9/1 14/09/11</i>			
240 <b>*240*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>18</i>			DAS 38 9-89 <i>14-9-12</i>

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Item ID: D350-591-311

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 8/13/14

Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 8/13/14

Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

10X

DAS  
28  
9-89

SEP 22 2014

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

10

DAS  
38  
9-89

14-9-12

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311  
Location: 084

5

SEP 18 2014

DAS  
06  
9-89

Doc

**Work Order ID 123580****\*123580\***

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Item ID: D350-591-311 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Heli-Access-Step™ LH  
Start Date: 8/13/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 8/13/14 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

*MW 1409-19*

*MF 14-9-19*

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Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC  
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	10.0000	1	10			
<b>*D3272-1*</b>													
Step													

Location	Loc Qty	Loc Code
WA003 3123345	10	
122258	10	

D3067-1		Manufactured	No			110	Each	462.0000	1	10			
<b>*D3067-1*</b>													
End Plate													

Location	Loc Qty	Loc Code
WA003	462	
101785	67	
102686	14	
116323	6	
117776	225	
119290	150	

D3219-1		Manufactured	No			110	Each	189.0000	2	20			
<b>*D3219-1*</b>													
Plate													

Location	Loc Qty	Loc Code
WA003	189	
112125	8	
114934	60	
115339	121	



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Work Order ID: 123580

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Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each 206.0000 2 20

**\*D3066-1\***

Spacer

**\*\***

DMC 14-09-04

Location	Loc Qty	Loc Code
WA003	206	
106302	7	
<u>115867</u>	52	(20x)
115868	52	
115869	60	
117799	35	

MS20600-AD4W4 Purchased No

180 Each 3,236.000 16 160

**\*MS20600-AD4W4\***

Rivets

**\*\***

DMC 14-09-04

Location	Loc Qty	Loc Code
ST310	3236	
125577	215	
M128429	149	
<u>M128899</u>	2872	(160x)

D3065-041 Manufactured No

180 Each 32.0000 1 10

**\*D3065-041\***

Step Leg Assembly

**\*\***

DMC 14-09-04

Location	Loc Qty	Loc Code
WA003 <del>B123378</del>	32	(10x) B123378 cpc
102830	6	
109447	2	
113075	2	
115696	10	
115697	12	

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**\*123580\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

462.0000

1

10

**\*D3067-1\***

End Plate

**\*\***

*CC 14-8-9*

Location

Loc Qty

Loc Code

WA003

462

101785

67

102686

14

116323

6

117776

225

119290

150

*TOX*

AN3-35A

Purchased

No

250

Each

167.0000

2

20

**\*AN3-35A\***

Bolt

**\*\***

*14-9-11*

DAS  
38  
9-89  
DAS  
38  
9-89

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

156

m128634

6

m129706

50

m129934

100

ST352

1

m127460

1

*20x*

DAS  
28  
9-89

*SP*

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Work Order ID: 123580

**\*123580\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Manufactured No

250

Each

348.0000

2

20

**\*D3235-1\***

Mounting Lug

DAS  
38  
9-89

**\*\***

DAS  
28  
9-89

AP

Location

Loc Qty

Loc Code

ST519

348

102818

6

105939

17

108670

43

114441

54

116383

100

116384

58

116385

70

2x  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
18x

D3278-041

Manufactured No

250

Each

70.0000

1

10

**\*D3278-041\***

Support Assembly

DAS  
38  
9-89

**\*\***

DAS  
28  
9-89

AP

14-9-11

Location

Loc Qty

Loc Code

ST521

70

102349

1

109406

1

114169

39

114940

4

121431

25

\_\_\_\_\_  
\_\_\_\_\_  
1x  
\_\_\_\_\_  
1x  
10x, 8x

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t

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Work Order ID: 123580

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*123580\***

**\*D350-591-311\***

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0463J

Purchased

No

250

Each

6,572.000

16

160

**\*NAS1149D0463J\***

DAS

38

WASHER

9-89

**\*\***

DAS

28

9-89

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

6087

16941

8

M126221

20

M127813

6

M127904

127

M128591

44

M128995

1500

M129390

4382

100X

NAS1149D0563J

Purchased

No

250

Each

2,249.000

4

40

**\*NAS1149D0563J\***

DAS  
38  
9-89

Washer

**\*\***

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

129

m125807

129

ST510a

2120

m126319

128

m128257

1992

40X

AN5-36A

Purchased

No

250

Each

113.0000

2

20

**\*AN5-36A\***

DAS  
38  
9-89

Bolt

**\*\***

14-9-11

Location

Loc Qty

Loc Code

ST336

113

M126105

1

M127410

7

M127460

96

M128850

9

20X

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Work Order ID: 123580

**\*123580\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

D2618

Manufactured No

250

Each

113.0000

2

20

**\*D2618\***

DAS  
38  
9-89

Bushing

**\*\***

DAS  
28  
9-89

Location

Loc Qty

Loc Code

ST008A

113

103863

3

114872

1

97780

109

20x

D2230-3

Manufactured No

250

Each

482.0000

4

40

**\*D2230-3\***

DAS  
38  
9-89

Mounting Lug

**\*\***

DAS  
28  
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

475

108668

1

109344

2

114151

1

114921

6

115583

146

116378

159

116379

160

38x

2x

D2856-400

Manufactured No

250

f

263.4000

1.2

12

**\*D2856-400\***

DAS  
38  
9-89

Abrasion Strip 4" Wide (Per Foot)

**\*\***

149-11

Location

Loc Qty

Loc Code

ST426

263.4

112524

47.4

117887

216

12

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

DAS  
28  
9-89

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Work Order ID: 123580

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*123580\***

**\*D350-591-311\***

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

3,746.000

2

20

**\*MS21042L3\***

DAS

38

9-89

Nut

**\*\***

DAS

26

9-89

Location

Loc Qty

Loc Code

ST307

3746

123900

948

M127410

11

M127831

41

M128401

42

M128754

2704

AN4-13A

Purchased

No

250

Each

749.0000

8

80

**\*AN4-13A\***

DAS

38

9-89

Bolt

**\*\***

14-9-11

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST515

713

m127432

36

m127817

22

m128739

655

DAS

26

9-89

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Work Order ID: 123580

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*123580\***

**\*D350-591-311\***

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

844.0000

2

20

**\*MS21042I 5\***

DAS

38

9-89

Nut

**\*\***

DAS

28

9-89

Location

Loc Qty

Loc Code

ST307

844

117611

1

125684

8

m127304

1

m127813

500

m128810

7

m129472

327

MS21042L4

Purchased

No

250

Each

5,124.000

8

80

**\*MS21042I 4\***

DAS

38

9-89

Locknut

**\*\***

Location

Loc Qty

Loc Code

ST307

5124

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

891

m128300

80

m128798

1535

m129472

1000

m129934

1500

DAS

28

9-89

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Work Order ID: 123580

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Parent Item: D350-591-311

\*D350-591-311\*

Parent Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14

Required Date: 8/13/14

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0363J

Purchased

No

250

Each

2,163.000

4

40

\*NAS1149D0363.J\*

DAS  
38  
9-89

Washer

\*\*

14-9-11

DAS  
28  
9-89

(10)

Location

Loc Qty

Loc Code

GA

23

124392

23

ST276

5

m123441

5

ST510a

2135

m128429

2135

40X

DSI9410-04

Sx

B 115899 x2 (OP) 14/09/18

(115899)

x1

113447

x1 (OP)

14/09/18

124573

x2 (OP)

14/09/18

DAS  
06  
9-89

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DESIGN <i>90</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

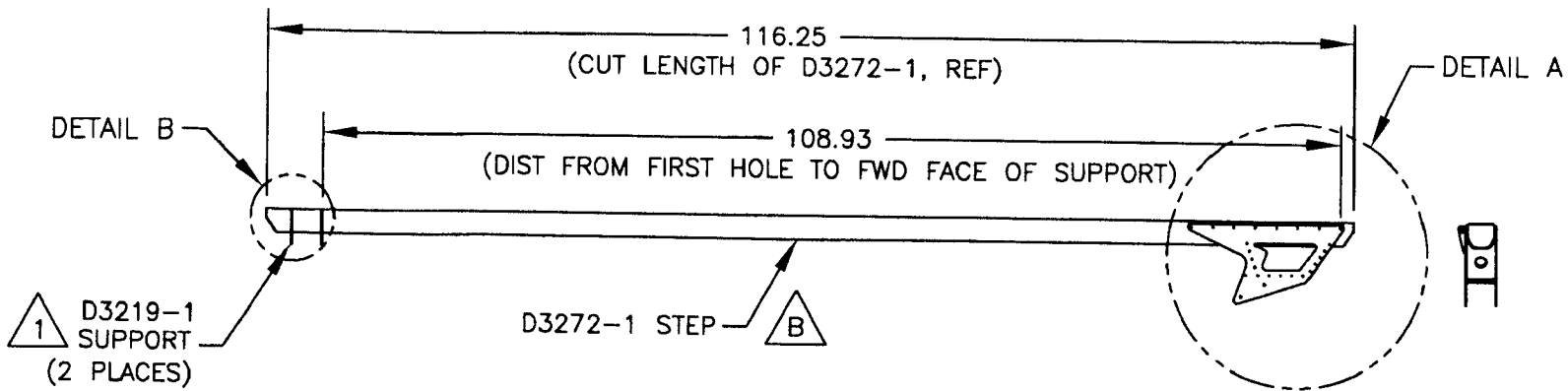
14-08-13  
123580 MJS  
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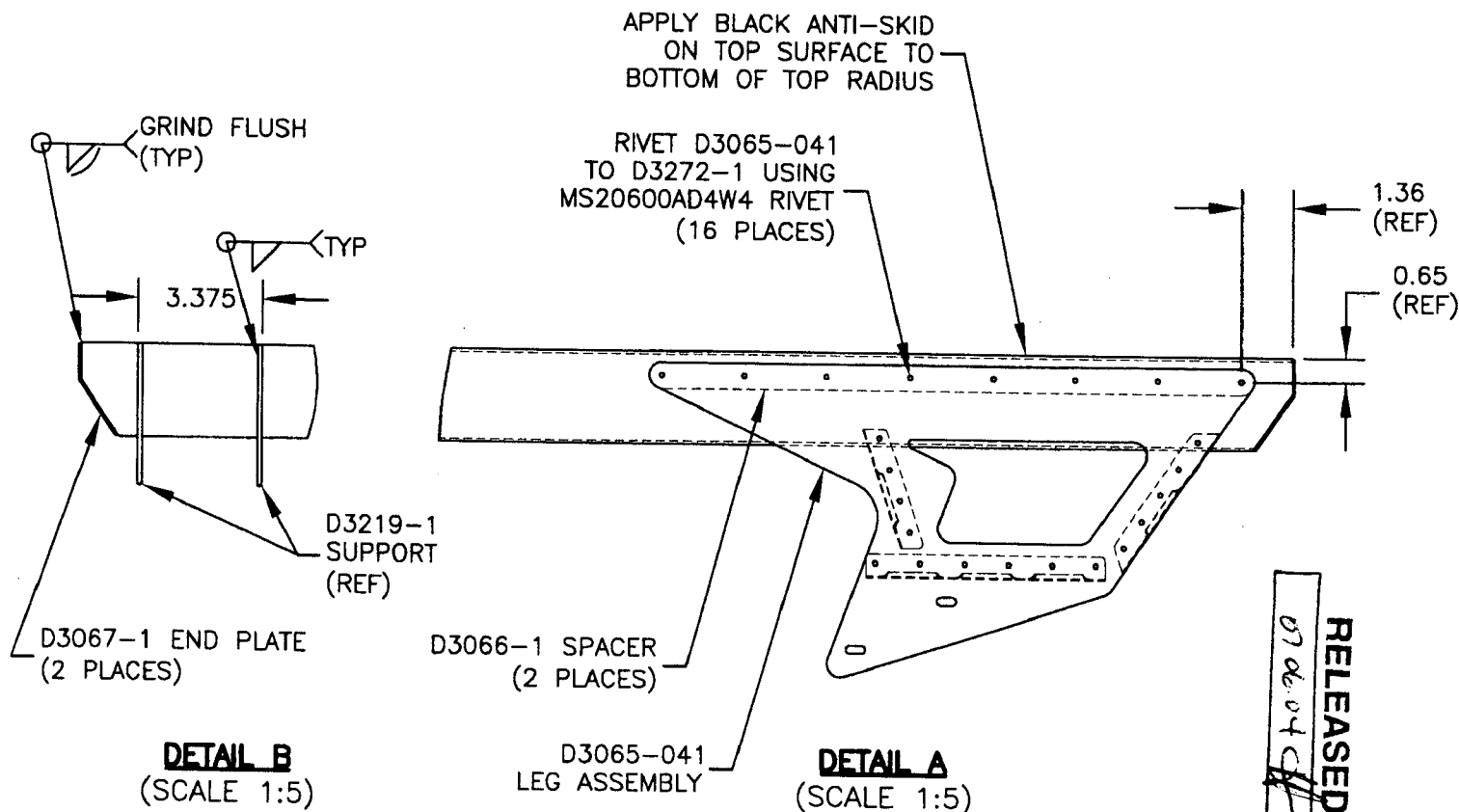
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**DART**

DESIGN	QC	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	REV. B
DATE	07.05.18	DRAWING NO.	D3272
		TITLE	STEP ASSEMBLY, HI LONG
		SHEET 2 OF 3	SCALE 1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

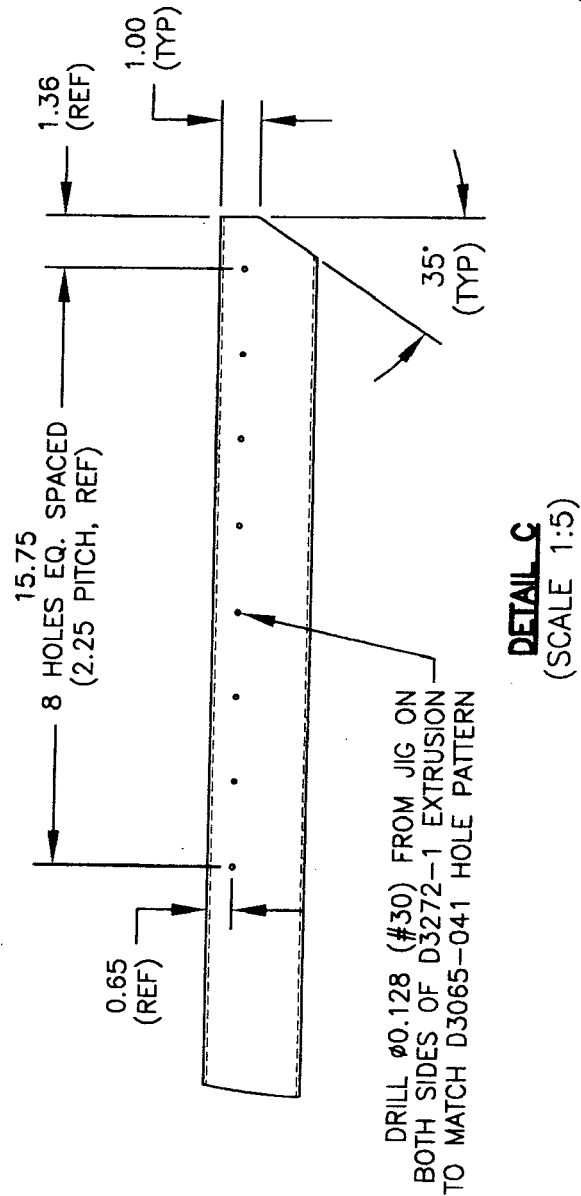
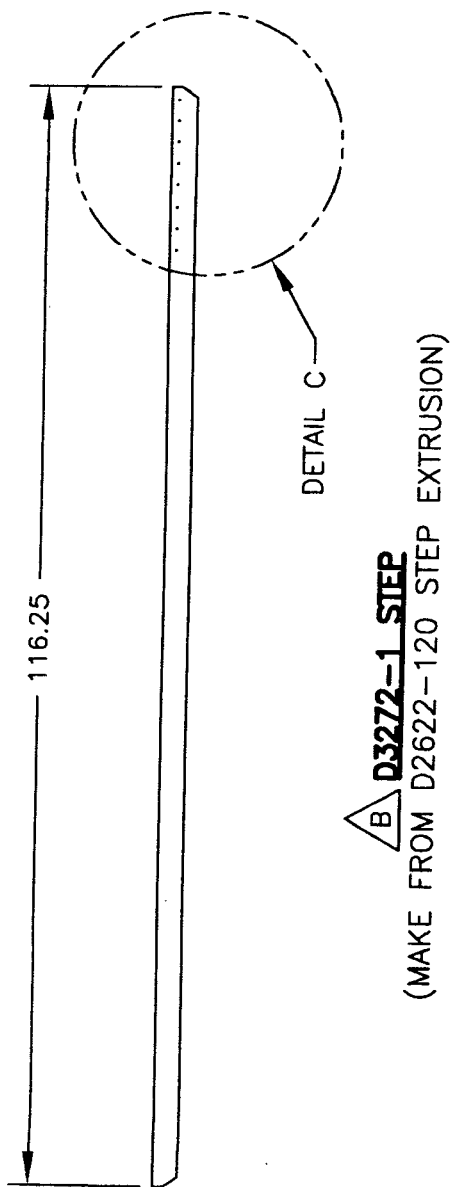




DESIGN <i>gp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

07.06.04 *[Signature]*



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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Work Order ID 123580

August-13-14 7:59:24 AM

\*123580\*

Page 1

Item ID: D350-591-311

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 8/13/14 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 8/13/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

MLS

Date: 14-08-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	Document Control	0.00							
*100*	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								
110	Large Fab	0.00							
*110*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod								
	3-Grind End Plate flush								

MLS

14-09-11

10

0

DWG

14-08-25